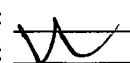
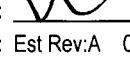


Date: Tuesday, 20/01/2009 2:32:06 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD RH HARDPOINT
Job Number :	44960		
Estimate Number :	13749		
P.O. Number :		Part Number :	D3870042
This Issue :	20/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3870 PRELIM
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	PRELIM
Written By :		Material :	
Checked & Approved By :		Due Date :	27/01/2009
Comment :	Est Rev:A 09-01-20 as per prelim issue DD verified by:ec		



Qty: 4 Um: Each

Additional Product

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation:

Description :


1.0 D38701 Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Base

batch: 344958

 09.01.21 4


2.0 D38703 Rib



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rib

batch: 344959

 09.01.21 4

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1




Comment: LARGE FABRICATION RESOURCE 1

1- assemble D3870-1 to D3870-3 and weld as per dwg D3870

****It is acceptable to grind corners to facilitate fitting to the D3870-1****

A/R Aluminum welding rod batch: M109560

 09.01.27 4

4.0 QC9 VISUAL WELDING INSPECTION




Comment: VISUAL WELDING INSPECTION

PD 09.01.27 (9)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL
 09.01.27 4x

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:32:06 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD RH HARDPOINT

Job Number: 44960

Part Number: D3870042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

SS 09-01-27 X

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/01/27 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock
Location: PPD 44964

SS 09/01/28 (X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 HJ

Job Completion



09.01.28

POSITIVE RECALL
EFFECTIVE 09.01.20 AUTH W
RELEASED 1 DATE 09.02.17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

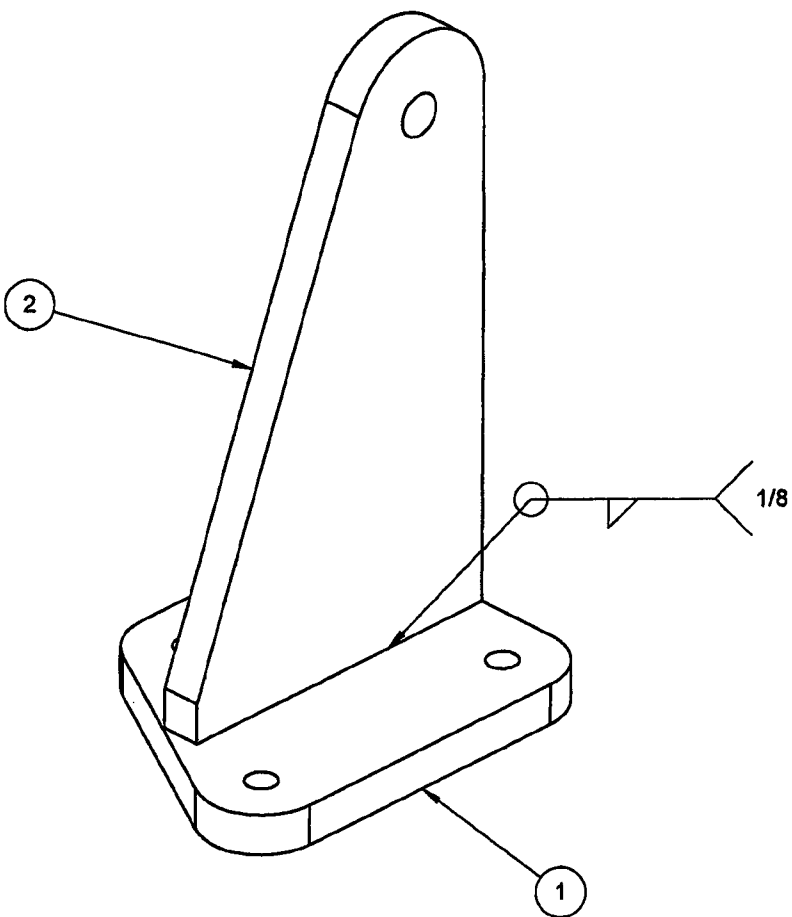
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3870-1	BASE	1
2	D3870-3	RIB	1









PRELIMINARY ISSUE
09/01/15
44960

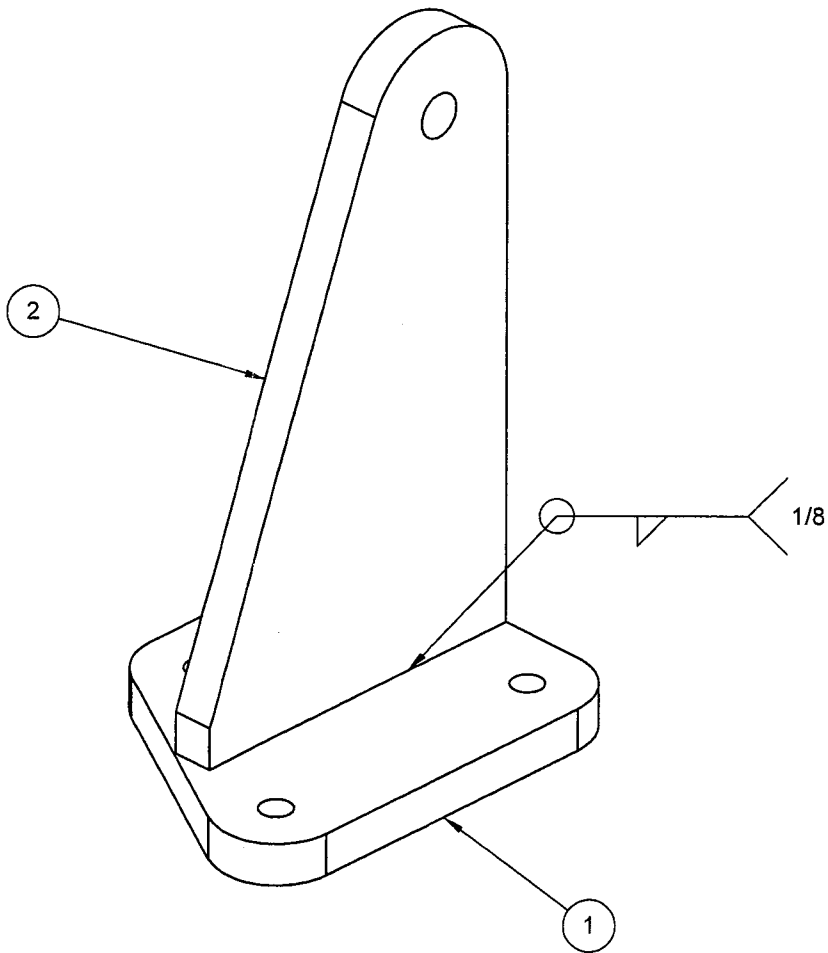
D3870-042 FWD RH HARDPOINT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-042" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs
- 8) WELD PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.12.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3870-1	BASE	1
2	D3870-3	RIB	1



D3870-042 FWD RH HARDPOINT

44960
RELEASED
11/01/12 M/A

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-042" & B/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.09 lbs
 8) WELD PER DART QSI 004

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3870	SHEET 2 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	MOUNT	NTS
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